

**Personal Safety**

• Comfort Particle Mask P2



• Hearing Protection



• Face Protection



• Reusable Workwear



• Safety Gloves



<p><b>1</b> Host Panel Preparation</p>		<ul style="list-style-type: none"> <li>After the removal of the outer panel, remove any remaining material and contaminants from host panel. Prep remaining mating flanges on host panel with a Scotch-Brite™ Belt or Disc.</li> </ul>	<p>3M™ Scotch-Brite™ File Belts    3M™ Pistol Grip Disc Sander    3M™ Scotch-Brite™ Roloc Disc    3M™ Cut-Off Wheel Tool ø 75 mm, ø 100 mm</p>
<p><b>2</b> Cleaning of the surface</p>		<ul style="list-style-type: none"> <li>Degrease host panel mating flange areas using a general purpose adhesive cleaner with fast flash off.</li> </ul>	<p>3M™ General Purpose Adhesive Cleaner    3M™ Professional Panel Wipes</p>
<p><b>3</b> Replacement Panel Preparation</p>		<ul style="list-style-type: none"> <li>Remove the E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt.</li> </ul> <p>Caution: E-Coat should only be removed in areas where adhesive is recommended by the vehicle manufacturer.</p>	<p>3M™ Scotch-Brite™ File Belts    3M™ File Belt Tool</p>
<p><b>4</b> Cleaning of the surface</p>		<ul style="list-style-type: none"> <li>Degrease host panel mating flange areas using a general purpose adhesive cleaner with fast flash off.</li> </ul>	<p>3M™ General Purpose Adhesive Cleaner    3M™ Professional Panel Wipes</p>
<p><b>5</b> Corrosion Protection</p>		<ul style="list-style-type: none"> <li>Apply Zinc Rich weld-thru coating to all areas on host panel and replacement panel requiring welding operations. <u>Do not</u> apply in areas requiring adhesive</li> <li>Two layers are recommended to obtain the right coating thickness for optimum corrosion protection</li> <li>Drying time: 10 - 20 minutes</li> </ul>	<p>3M™ Weld Thru II Primer</p>
<p><b>6</b> Calibration of a new cartridge</p>		<ul style="list-style-type: none"> <li>Insert the cartridge into an applicator gun designed for the adhesive cartridge.</li> <li>Before attaching the mixer to the cartridge, squeeze out a small amount of material until both components are equally extruded.</li> <li>Attach the mixing nozzle and discard the first 2-4 cm of extruded material, to remove any improperly mixed material.</li> <li>Note: The previous step is only necessary when using a new cartridge</li> </ul>	<p>3M™ Panel Bonding Adhesives    3M™ Manual Applicator for 200ml Duopack Cartridge    3M™ Pneumatic Applicator for 200ml Duopack Cartridge</p>
<p>Pre-Assembly NVH Replacement</p>		<ul style="list-style-type: none"> <li>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</li> </ul>	<p>3M™ NVH Dampening Material</p>
<p><b>7</b> Application</p>		<ul style="list-style-type: none"> <li>Apply adhesive to mating flange areas on host panel and replacement panel. Spread the adhesive covering all bare metal areas with an acid brush or plastic applicator.</li> <li>Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness and all voids are filled.</li> </ul>	
<p><b>8</b> Install Replacement Panel</p>		<ul style="list-style-type: none"> <li>Install replacement panel to host panel by clamping in place, being careful to not scrape off any of the adhesive during the process.</li> <li>Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the repair procedure of the vehicle.</li> <li>Note: Follow recommended adhesive clamp times: Minimum 4 hours @ 23°C ambient temperature.</li> </ul>	
<p><b>9</b> Adhesive Clean Up</p>		<ul style="list-style-type: none"> <li>Tool excess adhesive squeeze-out from repair area once clamping is complete. Do not allow adhesive squeeze out to cure.</li> <li>Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.</li> </ul>	<p>3M™ General Purpose Adhesive Cleaner    3M™ Professional Panel Wipes</p>
<p>Post-Assembly Foam Replacement</p>		<ul style="list-style-type: none"> <li>Apply foams at original locations as required by the vehicle repair procedure.</li> <li>Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.</li> </ul>	<p>3M™ Flexible Foam    3M™ Rigid Pillar Foam</p>